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The second secon	r ID 73038 — T ust 24, 2011 2:24:44 PM						Page 1
Revision ID:	D3512-1 Wearplate	Particol Control				Setup Start Stop	
Start Date: 8 Required Date: 8 Reference:	8/24/2011 Start Qty: 1 8/31/2011 Req'd Qty: 1			Cust Item ID: Customer:			
-0.0	Process Plan: QC:	Date: //- St	Tooling: SPC (Y/N):	Date:		Run Start Stop	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool	# Plan Acce Code Qty		Reject Insp. Number Stamp
Draw Nbr	Revision Nbr						
D3512	Rev C						
Waterjet	FLOW WATER	10	0.00		B	PG-8-11d	
FLOW CNC Waterjet	Debi	irr if necessary	Rev: Prog Rev:	UZ-			(1)
QC Quality Control	QC2- Inspect par	ts off machine FAI/FAIB	0.00		T	311-8-59	
			a. T				
QC Quality Control	QC8- Inspect par		0.00 Sul	08/30	6	12	

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	ES	- valid		MEST. J.	
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					-				
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes I	No DQA	:	_ Date: _	H-1-1
	Res	olution:	Disposition	on:	QA: N/C Clo	sed:		_ Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR		di-		.
DATE	CTED	Description of NC		STATE OF THE PROPERTY OF THE P	ion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Work Order ID 73038

Page 2

Item ID:

D3512-1

Wednesday, August 24, 2011 2:24:44 PM

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Required Date: 8/31/2011

8/24/2011

Start Qty: 12.00 Reg'd Oty: 12.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop



Sequence ID/

Work Center ID

QC:

Operation

Set Up/

Tool ID

Tool# Plan Code

Accept Qtv

Reject Oty

Reject Insp. Number Stamp

130

Brake NC

Brake NC

Description

NC BRAKE

Run Hours

0.00

Deburr if necessary Form as per dwg D3512 using DT8179 SB [169]ott

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Large Fab Large Fab

Large Fab

0.00

Description

Memo

Memo

Weld hard surface using DT8874 as per Dwg D3512 & QSI Q04 □Qtx Batch A/R 2059b Hardcoat Rod

0.00

x2 11-09-07 JBL.

Dart A	erospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES	144	ALIEN Y	
DATE	STEP	PRO	OCEDURE CHA	INGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval' QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	lo DQA:	Date: _	
		esolution:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)		B07 I	
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 73038

Wednesday, August 24, 2011 2:24:44 PM



Page 3

Item ID:

D3512-1

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Wearplate 8/24/2011

Start Oty: 12.00

Reg'd Oty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 8/31/2011

Process Plan:

Date:

Tooling:

Date:

Run

Reject

Qty

Start

Stop

Insp.

Stamp

Reject

Number

OC:

Date:

SPC (Y/N):

Date:

Plan

Code

Tool#

Stop

Sequence ID/

Work Center ID

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Memo

Set Up/ Run Hours

170

Quality Control

QC5- Inspect part completeness to step on W/O

Suloslor

Accept

Qty

180

Powdercoat

W117338

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

2x 8 m/1/09/07

Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANG	ES			-
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date G	Approva Chief Eng Prod Mgr	Approval' QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:_	Date:	
	Res	solution:	Dispositio	n:	QA: N/C Cld	sed:	Date:	190
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)	HEIRE	
DATE	STED	Description of NC				Verificati	on Approva	I Approval
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		PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Description Sign & Section C Sectio						
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Work Order ID 73038

Wednesday, August 24, 2011 2:24:44 PM



Page 4

Item ID:

D3512-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Wearplate Item Name:

Required Date: 8/31/2011

8/24/2011

Start Qty: 12.00

Reg'd Oty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

Date:

Start



OC:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/ Work Center ID

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Oty

Reject Number

Insp. Stamp

Identify as per dwg & Stock Location:

Packaging

Packaging

200

Memo

210

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mc 09-07

Dart	Aeros	pace	Ltd
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	Charles Helling								90
W/O:			WC	RK ORDER CHANG	ES	THE STATE OF THE S		26	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval' QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	_ Date: _	
		olution:							
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			7,-
DATE	STEP	Description of NC			ion B	Verifica	ation	Approval	Approval
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Picklist Print

Wednesday, August 24, 2011 2:24:53 PM

Work Order ID: 73038

Parent Item:

D3512-1

Parent Item Name: Wearplate



Start Date: 8/24/2011

Required Date: 8/31/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM

IPP Rev:B Now SS as per Rev B 06-12-15 JLM IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	203.6000	0.261	3.296842			
										BIL	- E-3-		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	120	
118578	120	
MAT021	83.6	
118217	83.6	



Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	SES	11/11		1127	
DATE	STEP	PROC	EDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval* QC Inspector
			-			19.00			
						<u> jjik</u>			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Dispositio	n:	_ QA: N/C CI	osed:		_ Date: _	
NCR:		W	ORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	0750	Description of NC		Corrective Action Sec	tion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
						117			
						- 57			
				8		14.5			
							H		

DART AEROSPACE LTD	Work Order:	73038
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512 Rev: C		Page 1 of 1

		X First A	rticle	Prof	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
0.375	+/-0.010	313	8		V B62		
12.600	+/-0.010	12,600	8		T BOI		
0.145	+/-0.010	,141	7		V		
0.750	+/-0.010	754	7		V		
2.631	+/-0.010	2.630	۷		V		
2.341	+/-0.010	2.345	9		V		
1.240	+/-0.010	1.243	>		V		
0.220	+/-0.010	- 991	7		V		
0.380	+/-0.010	383	>		V		
0.063	+/-0.010	(820,	9		V		
leasured by:	B	Audited b	y: 6	,	Prototype Appr	oval:	N/A

Measured by: B	Audited by:	1	Prototype Approval:	N/A
Date: 11-8-39	Date:	1/02/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM 1.0	
В	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	120

